



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D2876
Job Sheet 179682



Part No: D2876

Job Qty: 24 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B Esr Rev:B 00.05.19 Added inspect level 8 EC IPP Rev:C Now M6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		7/18/18	0.00	0.00	Start Up Waterjet		SC 180703
100	Waterjet	24 pcs		7/18/18	0.00	0.53	Waterjet1		SC 180703
120	QC	24 pcs		7/18/18	0.00	0.00	QC8		38
140	HandFinish	24 pcs		7/18/18	0.00	0.24	HandFinish1		SA 18-07-05
150	QC	24 pcs		7/18/18	0.00	0.00	QC7-1		38
160	Packaging	24 pcs		7/18/18	0.00	0.00	Packaging3		JUL 24 2018
170	QC21-SA	24 Ea		7/18/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut as per Dwg D2876
Descriptions:

DAS 21 JUL 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	1.2384 sf (.0516 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.100	1	44	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.980Inches ± 0.030	1.010 0.950	0,988	
2	Saddle Spacer	1.000Inches ± 0.030	1.030 0.970	1,002	
3	Saddle Spacer	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter 0,260	
4	Saddle Spacer	3.360Inches ± 0.030	3.390 3.330	3,366	
5	Saddle Spacer	2.480Inches ± 0.030	2.510 2.450	2,488	
6	Saddle Spacer	0.555Inches ± 0.010	0.565 0.545	0,558	

DQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspected Unapproved ☐ Rework ☐ Scrap ☐ Use-as-is Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab Cross tube ☐ Small Fab ☐ Finishing ☐ Composite Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier Engineering ☐ Quality ☐ Other		AGAINST DEPARTMENT/PROCESS		Date : _____ Step #: _____ Description Work Order Deviation 	
		QTY Effective : _____		MRB (Q51042) Approval Completed By _____ Hand / Supervisor _____ Approval Verification _____ QA Coordinator _____ Approval _____			
Container No: S088891 Part: D2876 Job No: 179682 Serial No/Batch: S088891 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com							
Root Cause							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		Pressure/ ☐ Bending ☐ Centre No ☐ Cracks ☐ Crimp/Kinl ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter OTHER : _____			
Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			